

**PARTS LIST:**

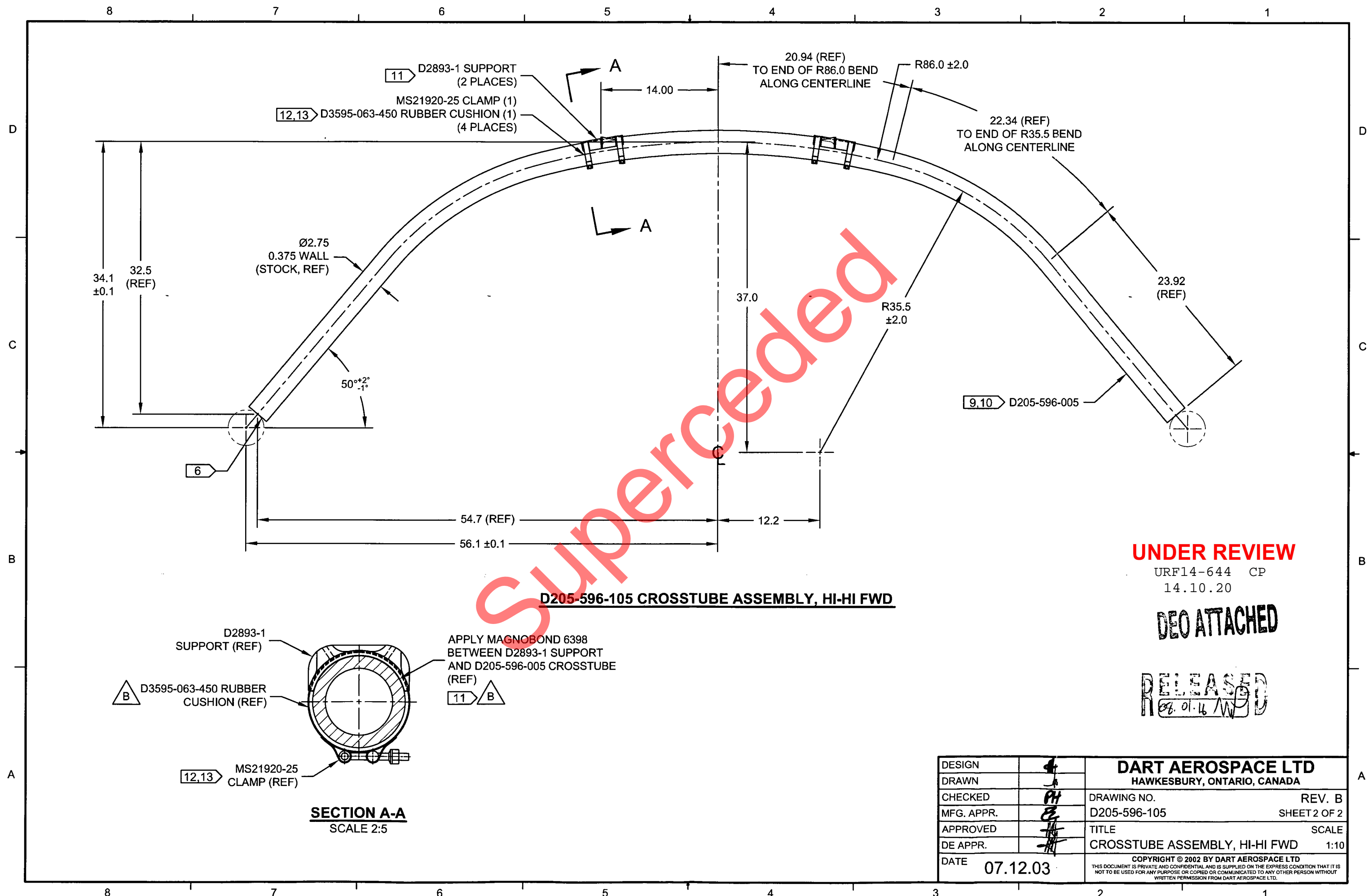
Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6005-180  
FINISHED LENGTH = 134.40 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.  
**NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR  
SHORTER (MS21920-24) CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A  
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.**
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

**UNDER REVIEW**URF14-644 CP  
14.10.20**DEO ATTACHED****RELEASED**  
06-01-16

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. REV. B D205-596-105 SHEET 1 OF 2	
CHECKED	<i>[Signature]</i>	TITLE SCALE	
MFG. APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI FWD NTS	
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
DE APPR.	<i>[Signature]</i>	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.12.03		



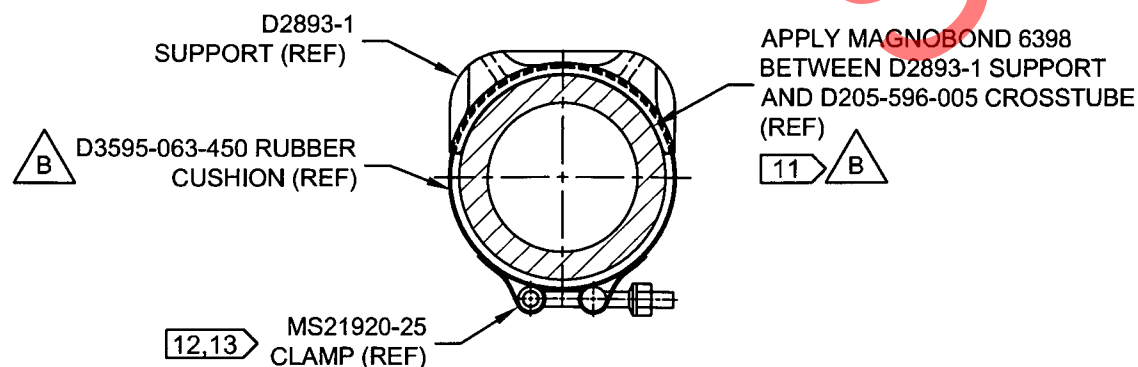
**D205-596-105 CROSSTUBE ASSEMBLY, HI-HI FWD**

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14.10.20

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**RELEASED**  
07.01.16



**SECTION A-A**  
SCALE 2:5

DESIGN	4	<b>DART AEROSPACE LTD</b>	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	E	D205-596-105	SHEET 2 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	CROSSTUBE ASSEMBLY, HI-HI FWD	1:10
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DRAWING NO. D205-596-105	TITLE CROSSTUBE ASS'Y, HI-HI FWD	REV. B	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D205-596-105-B-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>A</i>	APPROVED <i>10/10</i>		DE APPR. <i>11/11</i>		
DATE 13.11.11	DATE 13.11.19	DATE 13.11.19	DATE 13/11/21		DATE 13/11/21		

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL.

**CHANGE:**

IS:

Qty	Part Number	Description
A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 11 & 13, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 11) TO INSTALL D2893-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.

**RELEASED**  
2013-11-26

**UNDER REVIEW**

URF14-644 CP

DRAWING NO. D205-596-105	TITLE CROSSTUBE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D205-596-105-B-3	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>AA</i>	APPROVED <i>AB</i>		DE APPR. <i>AB</i>		
DATE 15.01.15	DATE 15.01.20	DATE 15.01.20	DATE 15.01.20		DATE 15.01.20		

**CHANGE:**

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Qty	Part Number	Description
X	D205-596-105B	CROSSTUBE ASSEMBLY (214 HI-HI FWD)

THE D205-596-105B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-105 CROSSTUBE EXCEPT AS FOLLOWS:

**IS:**

2	D5017-1	SUPPORT
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**WAS:**

2	D2893-1	SUPPORT
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INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-105 CROSSTUBE.

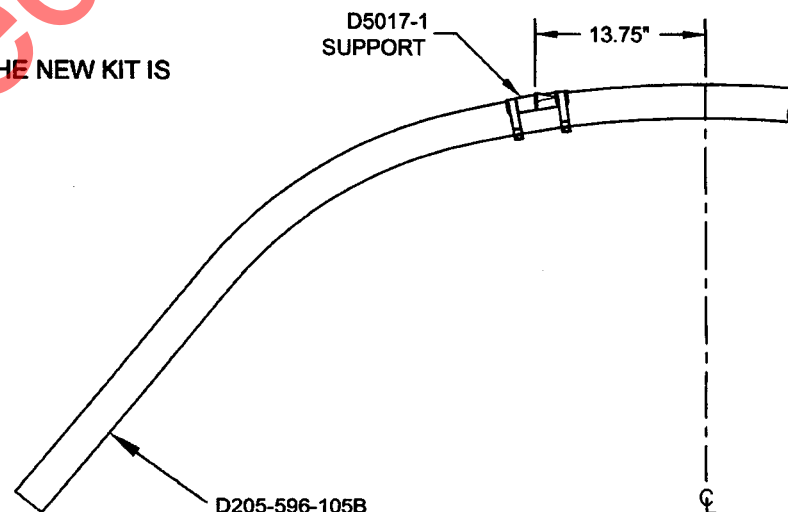
**RELEASED**

2015 JAN 26

ECN 15-510 *CP*

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URF14-644 CP



**FIGURE 1 - SUPPORT INSTALLATION**